

Work Order ID 105588

105588

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Item ID: D2697-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg

Start Date: 8/08/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/08/13 Req'd Qty: 1.00 *1* Customer:

Reference: REPOWDERCOAT *Rework*

Approvals: Process Plan: *u* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2697	Rev C								

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Hand Finishing

Memo

PULL FROM STK:
1 X D2697-2 B15061

STRIP COMPLETELY
RE-ALODINE

1 13-8-9

150 Black Sandtex (Ref:4.3.5.7) per QSI005 4.3 0.00

150

Powdercoat

Powder Coating

white 8-30 0.00

Memo

RE-POWDERCOAT WHITE PER QSI005

START TIME: 8 OVEN TEMPERATURE:

FINISH TIME:

3200F

9:00

1 X / M / 13/08/14

m/26/25

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Start Date: 8/08/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/08/13 Req'd Qty: 1.00 ***1*** Customer:
Reference: REPOWDERCOAT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>8T230</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

1x d ll 13/08/14

1x SP 13-8-15

13/8/20 ML5 13-08-15

Picklist Print

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Work Order ID: 105588

Parent Item: D2697-2

Parent Item Name: Leg

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2697-2 Leg		Manufactured	No				Each	1.0000		1			h

Location

Loc Qty

Loc Code

Mezz

1

15061

1

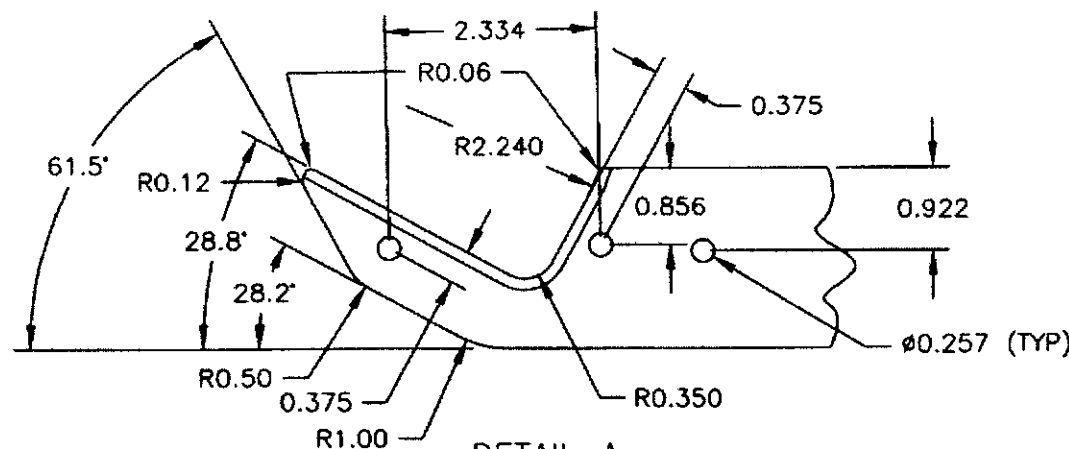
1

DART

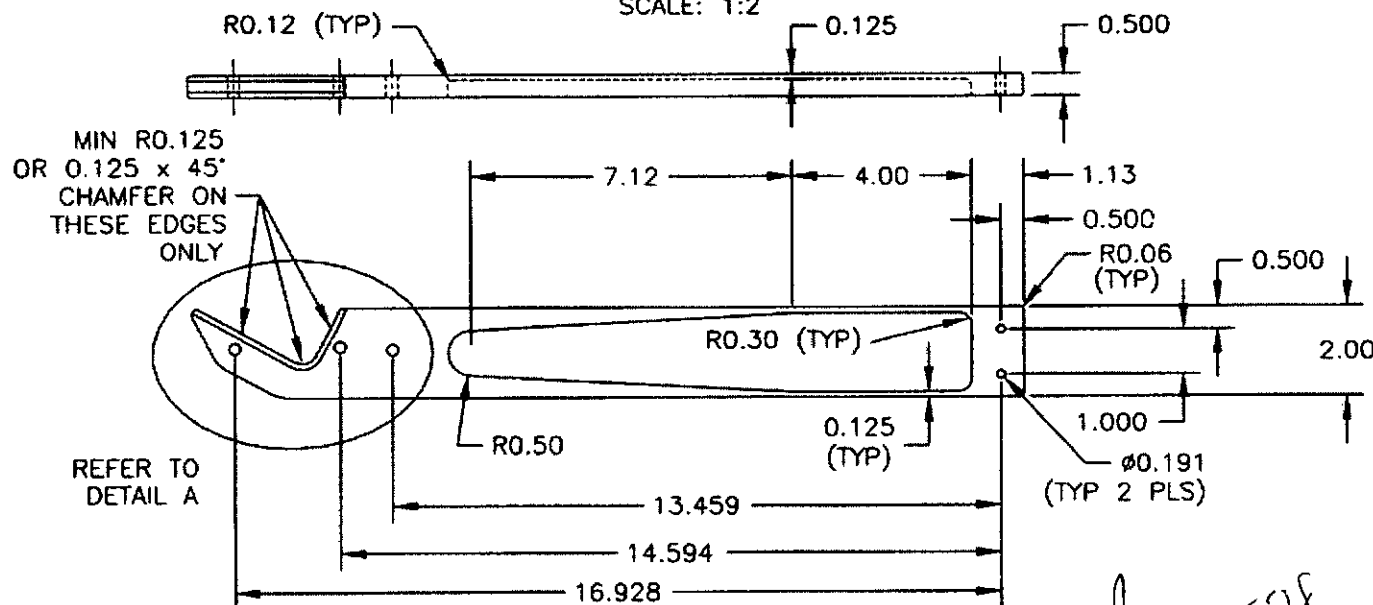


RELEASED
447 11 19

DESIGN	AE	DRAWN BY	AE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	AE	APPROVED	AE	DRAWING NO.	D2697
DATE	99.11.03	TITLE	STA 155 LEG	REV. C	SHEET 1 OF 1
A	97.09.10	NEW ISSUE		SCALE	1:4
B	99.10.20	UPDATE TOLERANCE, DELETE ENGRAVING			
C	99.11.03	CHANGED GEOMETRY IN DETAIL A ADDED FINISH			



DETAIL A
SCALE: 1:2



D2697-1 LEFT HAND (SHOWN)
D2697-2 RIGHT HAND (OPPOSITE)

NOTE: DEBURR ALL EDGES R0.03 - R0.06
 MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR
 GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)

W/O 105508

